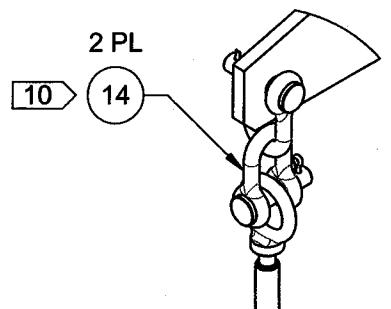
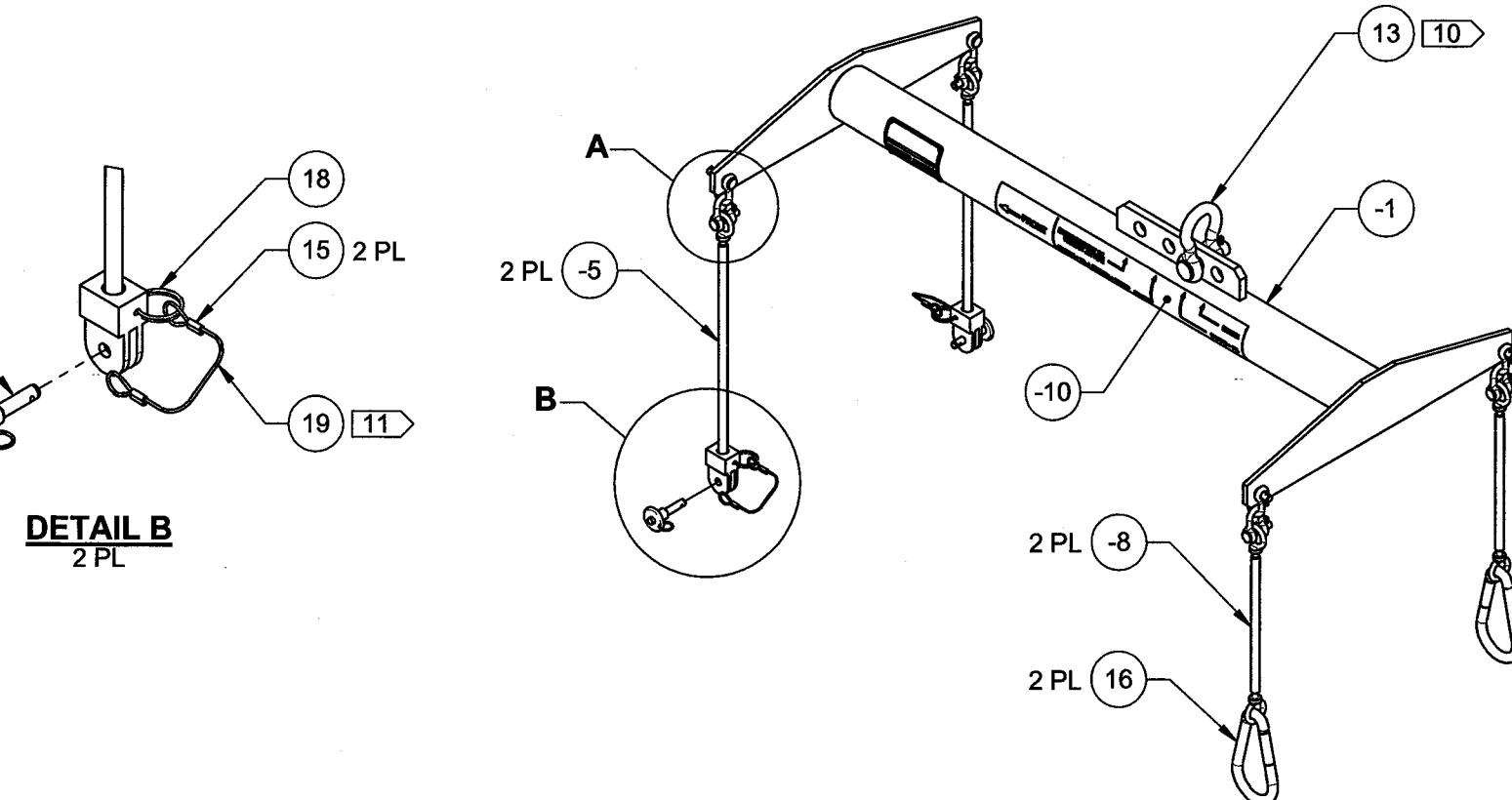
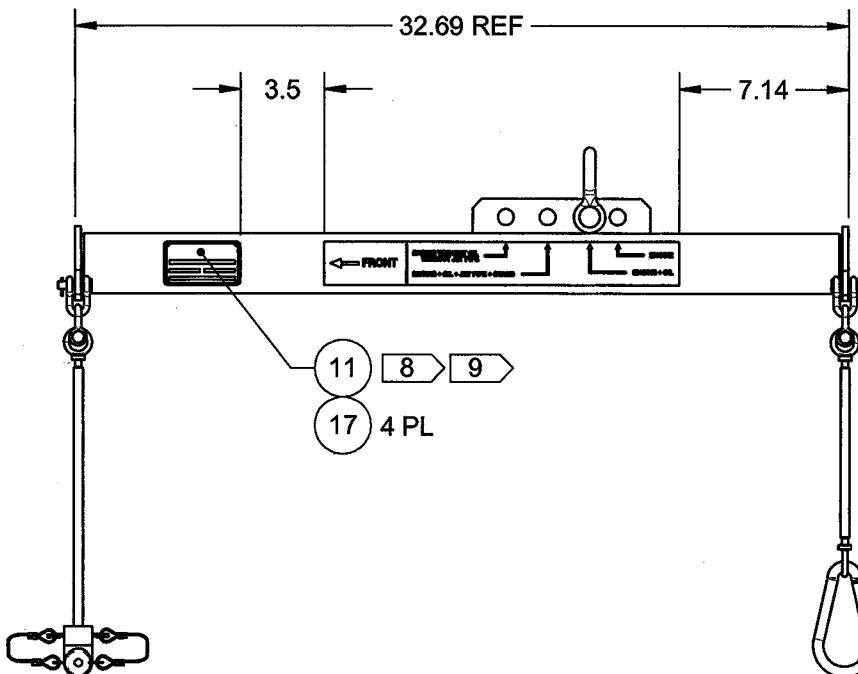


| ITEM # | QTY | PART #                       | PART TITLE  |
|--------|-----|------------------------------|---|
| -1     | 1   | RBE332A91-5490-00-1          | SLING WELDMENT  |
| -5     | 2   | RBE332A91-5490-00-5          | LEFT HAND ROD WELDMENT  |
| -8     | 2   | RBE332A91-5490-00-8          | RIGHT HAND ROD WELDMENT   |
| -10    | 1   | RBE332A91-5490-00-10         | STICKER   |
| 11     | 1   | RB41011                      | DART PLACARD  |
| 12     | 2   | MS17984C508                  | SS QUICK RELEASE PIN 5/16" DIA. X 0.800" GRIP LG.                                   |
| 13     | 1   | NAS1042-8                    | ZINC PLATED STEEL ANCHOR SHACKLE 13/16" OPENING WIDTH X 2830 LBS. MAX. WORKING LOAD |
| 14     | 8   | NAS1044-4                    | ZINC PLATED STEEL CHAIN SHACKLE 15/32" OPENING WIDTH X 710 LBS. MAX. WORKING LOAD   |
| 15     | 4   | McMaster#3896T31 OR EQUIV.   | ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.                         |
| 16     | 2   | McMaster#3933T18 OR EQUIV.   | ZINC PLATED STEEL CARABINER 5/8" OPENING WIDTH X 800 LBS. CAPACITY                  |
| 17     | 4   | McMaster#90081A077 OR EQUIV. | ZINC PLATED STEEL SCREW NAIL #2 SIZE X 1/4" LG.                                     |
| 18     | 2   | McMaster#90905A655 OR EQUIV. | 316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.                              |
| 19     | A/R | CARR-LANE#CL-2-C             | NYLON COATED STEEL LANYARD 1/16" DIA.   |

DETAIL A  
4 PL**RBE332A91-5490-00 MAKILA 2A SLING TOOL**

## NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SWL: 720 LBS" ON THE DART PLACARD WHERE INDICATED
- 7) ASSEMBLE AS SHOWN
- 8) FORM ITEM 11 TO OUTER DIAMETER OF ITEM -1 BEFORE INSTALLATION
- 9) TRANSFER DRILL HOLES FOR ITEM 17 THROUGH ITEM -1 TO INSTALL ITEM 11
- 10) BEND COTTER PIN PRONGS OF ITEMS 13 AND 14 AROUND SHACKLE PIN
- 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 12

|                |   |                           |     |
|----------------|---|---------------------------|-----|
| A              | SEE CAR 19-354 FOR DETAILED EXPLANATION OF CHANGES MADE | 19-1027                   | KPT |
| REV.           | DESCRIPTION   | ECN #                     | BY  |
| DESIGN         | KPT   | DART AEROSPACE LTD        |     |
| DRAWN          | KPT   | HAWKSLEY, ONTARIO, CANADA |     |
| CHECKED        | PM  | REV. A                    |     |
| MFG. APPR.     | DP  | SHEET 1 OF 12             |     |
| APPROVED       | W/O   | SCALE                     |     |
| DATE 1/10/2020 |   | NTS                       |     |

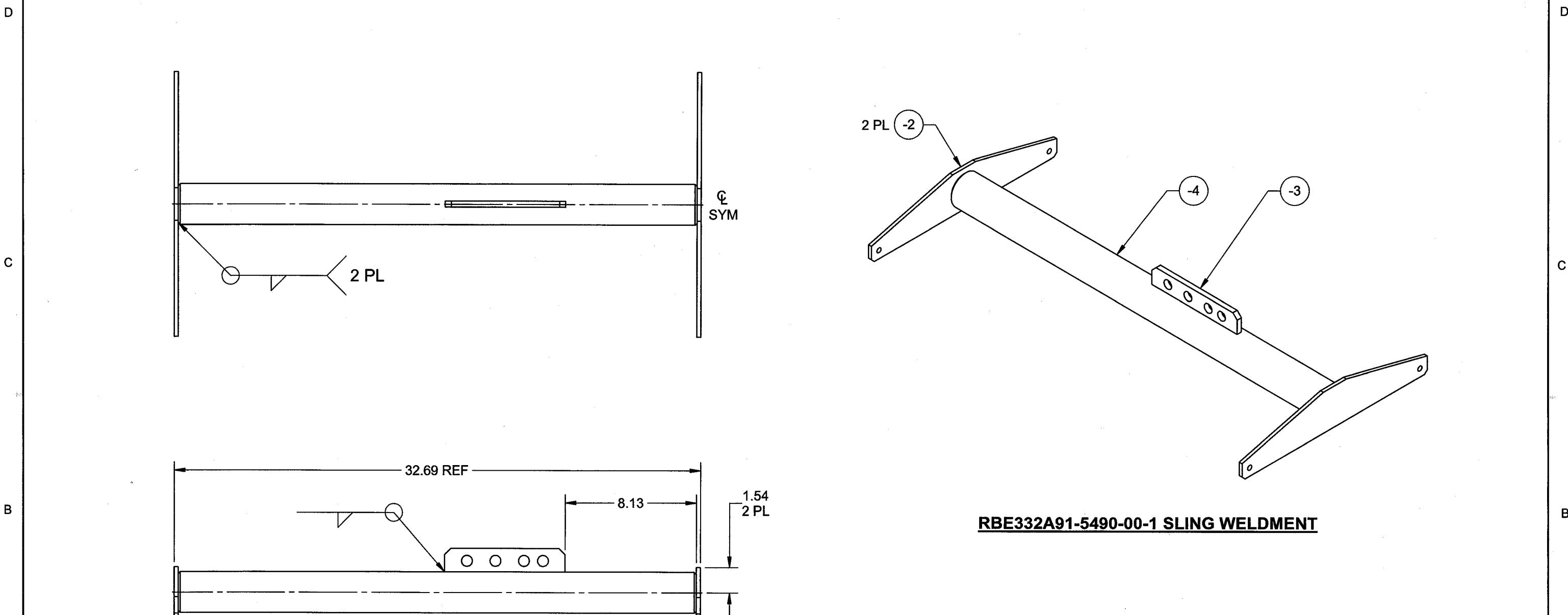
TOOL PART # **RBE332A91-5490-00**

TITLE **MAKILA 2A SLING TOOL**

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| ITEM # | QTY | PART #              | PART TITLE |
|--------|-----|---------------------|------------|
| -2     | 2   | RBE332A91-5490-00-2 | END PLATE  |
| -3     | 1   | RBE332A91-5490-00-3 | LIFT PLATE |
| -4     | 1   | RBE332A91-5490-00-4 | PIPE       |

**RBE332A91-5490-00-1 SLING WELDMENT****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

|            |           |
|------------|-----------|
| DESIGN     | KPT       |
| DRAWN      | KPT       |
| CHECKED    | PM        |
| MFG. APPR. | DP        |
| APPROVED   | NO        |
| DATE       | 1/10/2020 |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
**TOOL PART #**  
**RBE332A91-5490-00**  
**REV. A**  
**SHEET 2 OF 12**  
**SCALE** **NTS**  
**TITLE** **MAKILA 2A SLING TOOL**  
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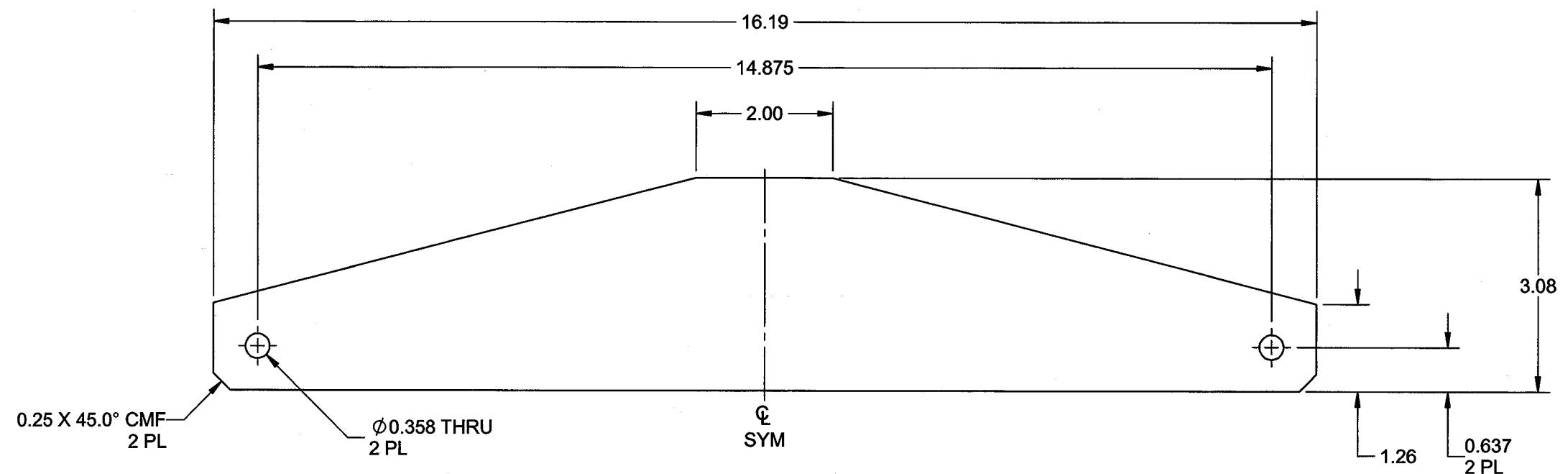
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**RBE332A91-5490-00-2 END PLATE**

NOTES:

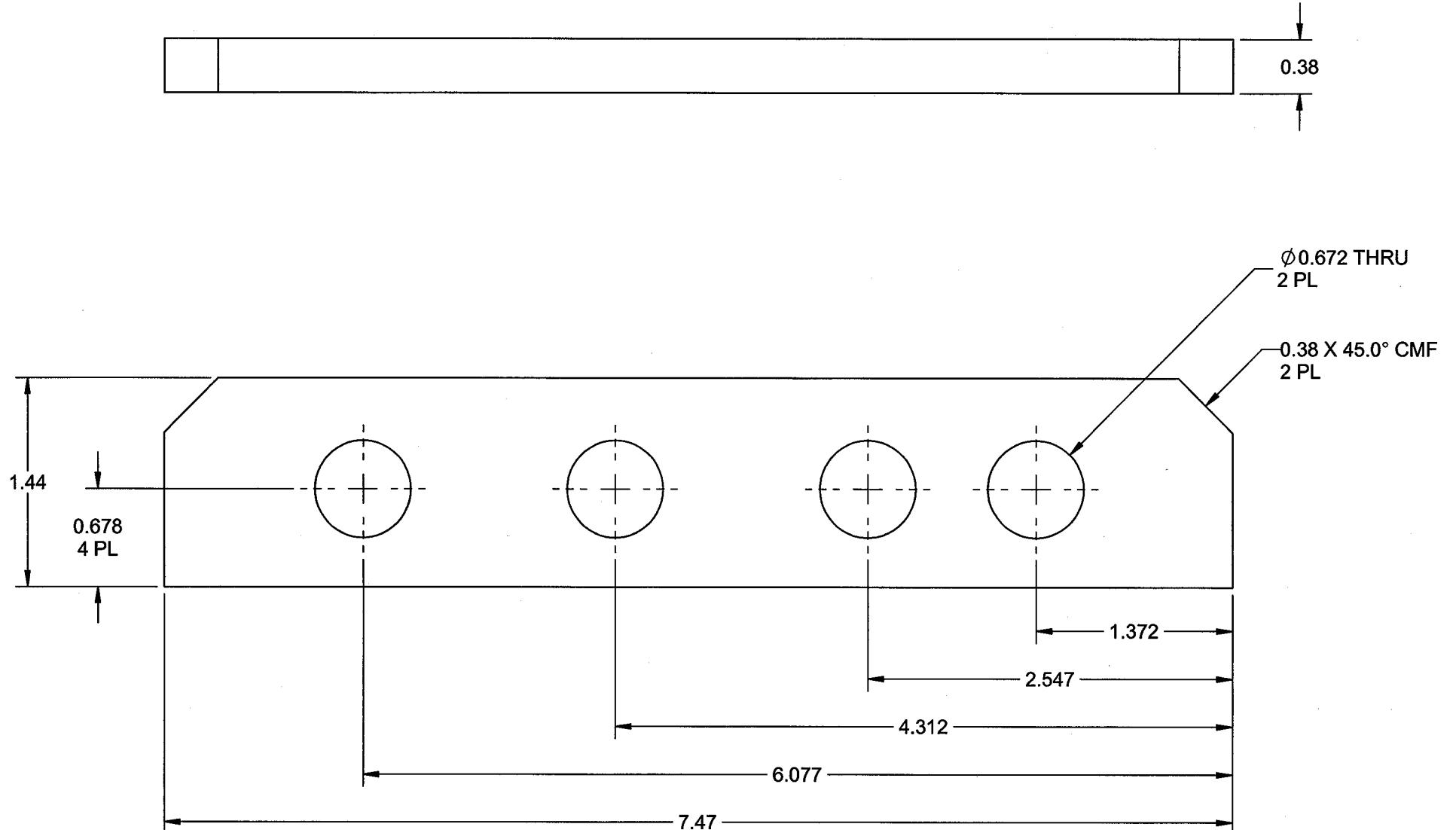
- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

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|--------------|-----------|
| DESIGN DRAWN | KPT KPT   |
| CHECKED      | PM DP     |
| MFG. APPR.   |           |
| APPROVED     | N/S       |
| DATE         | 1/10/2020 |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
REV. A  
TOOL PART # RBE332A91-5490-00  
TITLE MAKILA 2A SLING TOOL  
SCALE NTS  
SHEET 3 OF 12  
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### RBE332A91-5490-00-3 LIFT PLATE

#### NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

|                 |            |
|-----------------|------------|
| DESIGN<br>DRAWN | KPT<br>KPT |
| CHECKED         | PM         |
| MFG. APPR.      | DP         |
| APPROVED        | W/O        |

DATE 1/10/2020

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HAWKESBURY, ONTARIO, CANADA

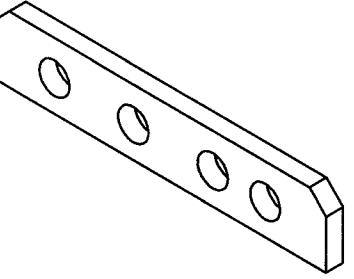
TOOL PART #  
**RBE332A91-5490-00**

REV. A:  
SHEET 4 OF 12

TITLE  
**MAKILA 2A SLING TOOL**

SCALE  
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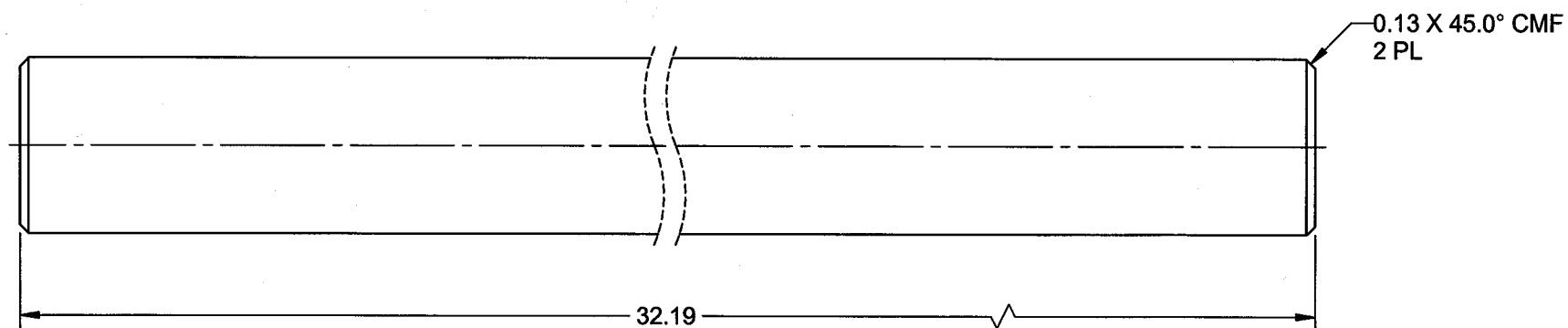
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**RBE332A91-5490-00-4 PIPE****NOTES:**

- 1) MATERIAL: A519 CDS TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

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|------------|-----------|
| DESIGN     | KPT       |
| DRAWN      | KPT       |
| CHECKED    | PM        |
| MFG. APPR. | DP        |
| APPROVED   | M0        |
| DATE       | 1/10/2020 |

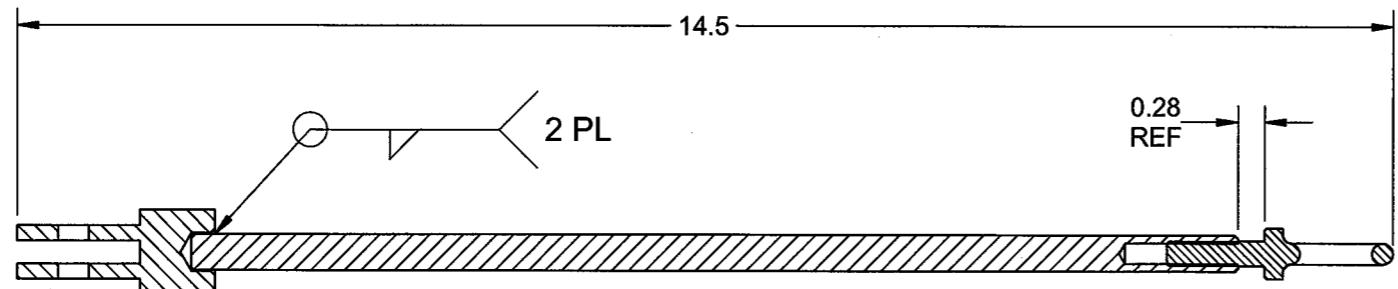
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| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| REV. A   |
| SHEET 5 OF 12  |
| TOOL PART # <b>RBE332A91-5490-00</b>                     |
| TITLE <b>MAKILA 2A SLING TOOL</b>                        |
| SCALE  |
| NTS  |

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| ITEM # | QTY | PART #              | PART TITLE  |
|--------|-----|---------------------|---|
| -6     | 1   | RBE332A91-5490-00-6 | LEFT HAND ROD                                       |
| -7     | 1   | RBE332A91-5490-00-7 | CLEVIS  |
| 20     | 1   | MS51937-21          | UNCOATED STEEL EYE BOLT 1/4"-28 X 1-1/32" SHANK LG. |

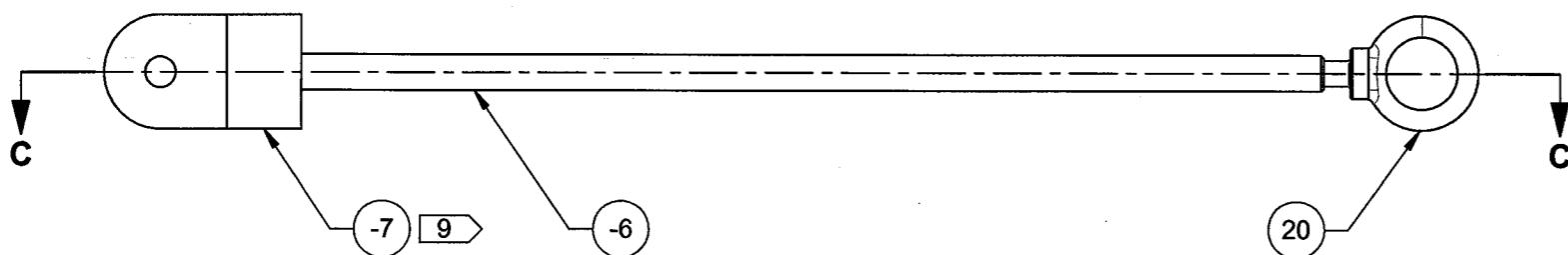
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SECTION C-C

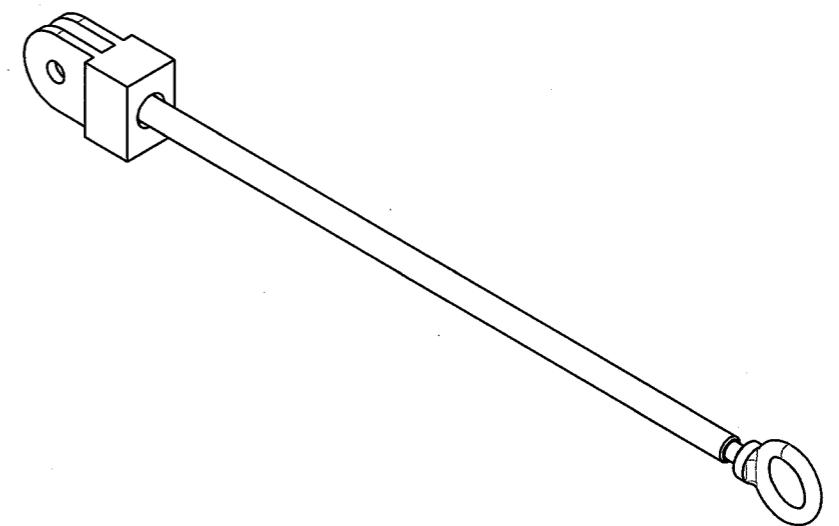
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RBE332A91-5490-00-5 LEFT HAND ROD WELDMENT

## NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS
- 9) MASK HOLES AND SLOTS OF ITEM -7 PRIOR TO POWDERCOAT FINISH

|                |     |
|----------------|-----|
| DESIGN         | KPT |
| DRAWN          | KPT |
| CHECKED        | PM  |
| MFG. APPR.     | DP  |
| APPROVED       | VO  |
| DATE 1/10/2020 |     |

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REV. A  
TOOL PART #  
**RBE332A91-5490-00**

SHEET 6 OF 12  
TITLE  
**MAKILA 2A SLING TOOL**

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SCALE  
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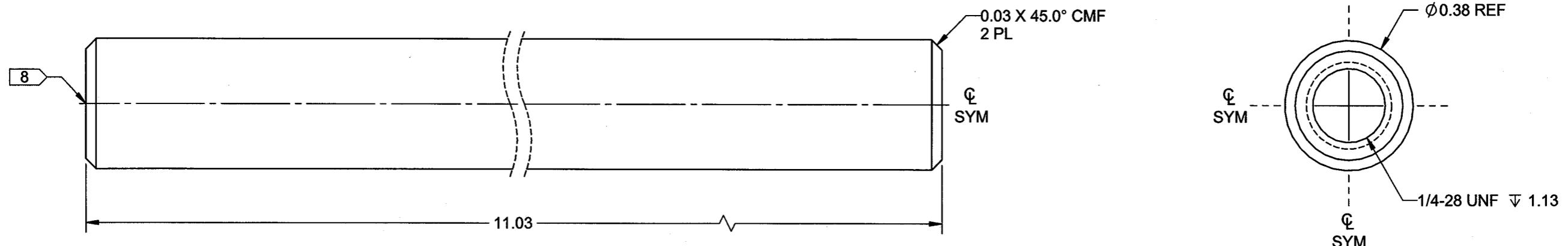
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**RBE332A91-5490-00-6 LEFT HAND ROD****NOTES:**

1) MATERIAL: McMaster#5252T315 OR EQUIV. (4140 ALLOY STEEL 3/8" DIA. ROD)

2) HEAT TREAT: 28-32 RC

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) CENTER DRILL IS ACCEPTABLE

|              |           |
|--------------|-----------|
| DESIGN DRAWN | KPT KPT   |
| CHECKED      | PM DP     |
| MFG. APPR.   |           |
| APPROVED     | M/O       |
| DATE         | 1/10/2020 |

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 TOOL PART #  
**RBE332A91-5490-00**

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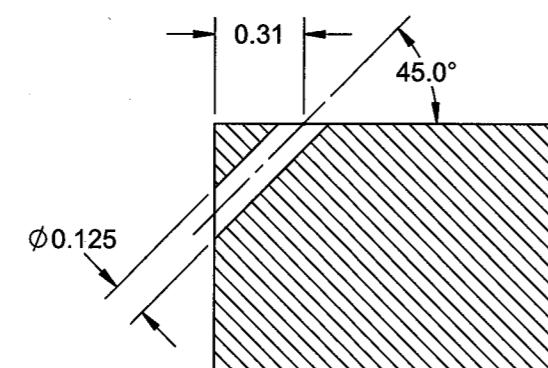
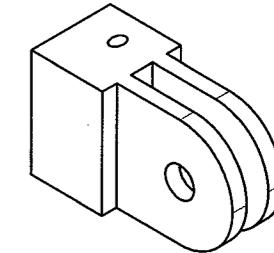
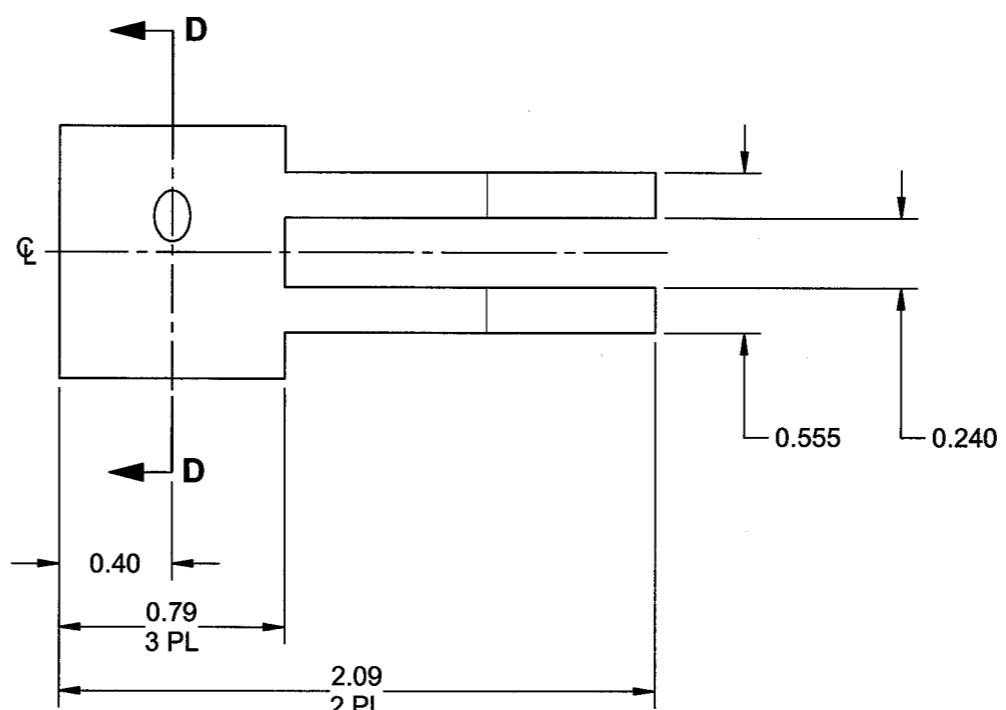
SHEET 7 OF 12

 TITLE  
**MAKILA 2A SLING TOOL**

 SCALE  
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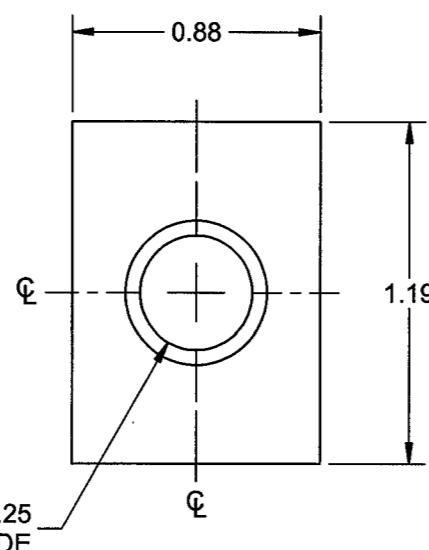
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**SECTION D-D**

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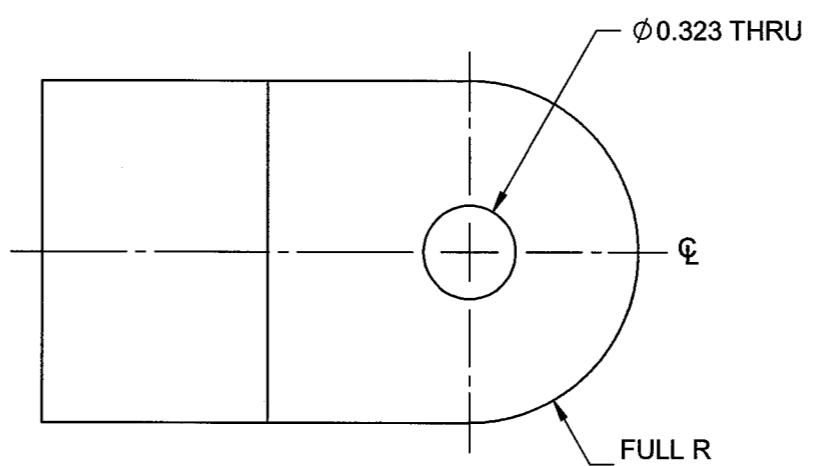
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✓  $\phi$  0.397  $\downarrow$  0.25  
 $\checkmark$   $\phi$  0.50 X 90°, NEAR SIDE

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**RBE332A91-5490-00-7 CLEVIS****NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

|            |           |
|------------|-----------|
| DESIGN     | KPT       |
| DRAWN      | KPT       |
| CHECKED    | PM        |
| MFG. APPR. | DP        |
| APPROVED   | WCO       |
| DATE       | 1/10/2020 |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

TOOL PART #  
**RBE332A91-5490-00**

REV. A

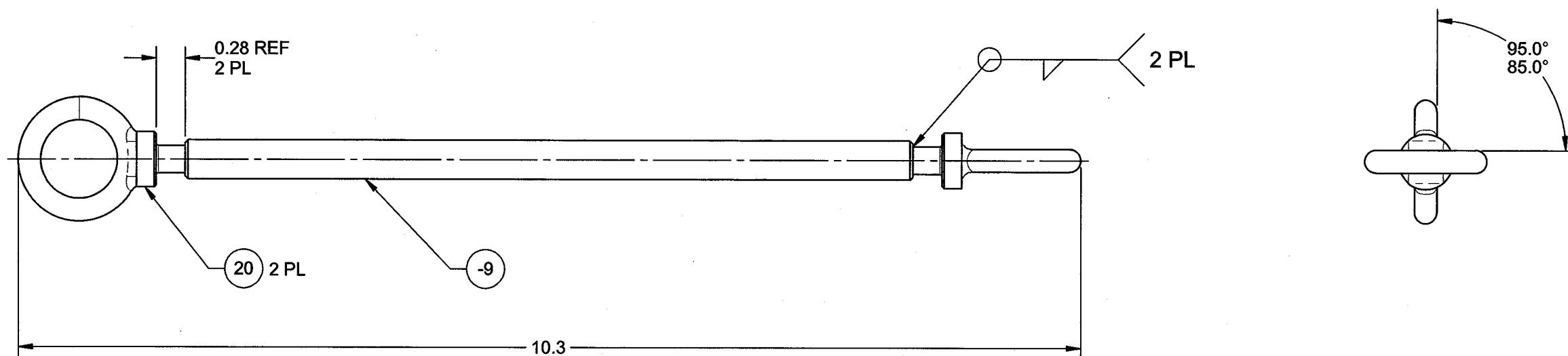
SHEET 8 OF 12

TITLE  
**MAKILA 2A SLING TOOL**

SCALE  
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| ITEM # | QTY | PART #              | PART TITLE  |
|--------|-----|---------------------|---|
| -9     | 1   | RBE332A91-5490-00-9 | RIGHT HAND ROD                                      |
| 20     | 2   | MS51937-21          | UNCOATED STEEL EYE BOLT 1/4"-28 X 1-1/32" SHANK LG. |



### RBE332A91-5490-00-8 RIGHT HAND ROD WELDMENT

#### NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

|                       |            |
|-----------------------|------------|
| DESIGN<br>DRAWN       | KPT<br>KPT |
| CHECKED<br>MFG. APPR. | PM<br>DP   |
| APPROVED              | ND         |
| DATE 1/10/2020        |            |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. A.  
TOOL PART #  
**RBE332A91-5490-00**  
SHEET 9 OF 12  
TITLE  
**MAKILA 2A SLING TOOL**  
SCALE   
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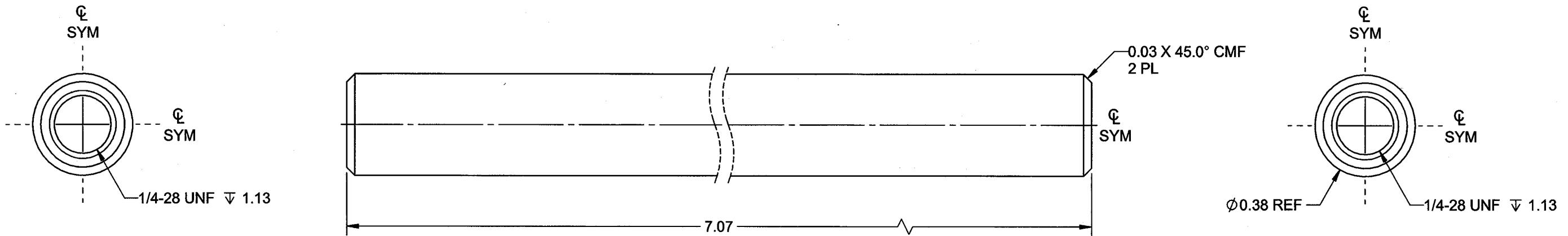
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### RBE332A91-5490-00-9 RIGHT HAND ROD

#### NOTES:

- 1) MATERIAL: McMaster#5252T315 OR EQUIV. (4140 ALLOY STEEL 3/8" DIA. ROD)
- 2) HEAT TREAT: 28-32 RC
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

|                 |            |
|-----------------|------------|
| DESIGN<br>DRAWN | KPT<br>KPT |
| CHECKED         | PM         |
| MFG. APPR.      | DP         |
| APPROVED        | NO         |
| DATE            | 1/10/2020  |

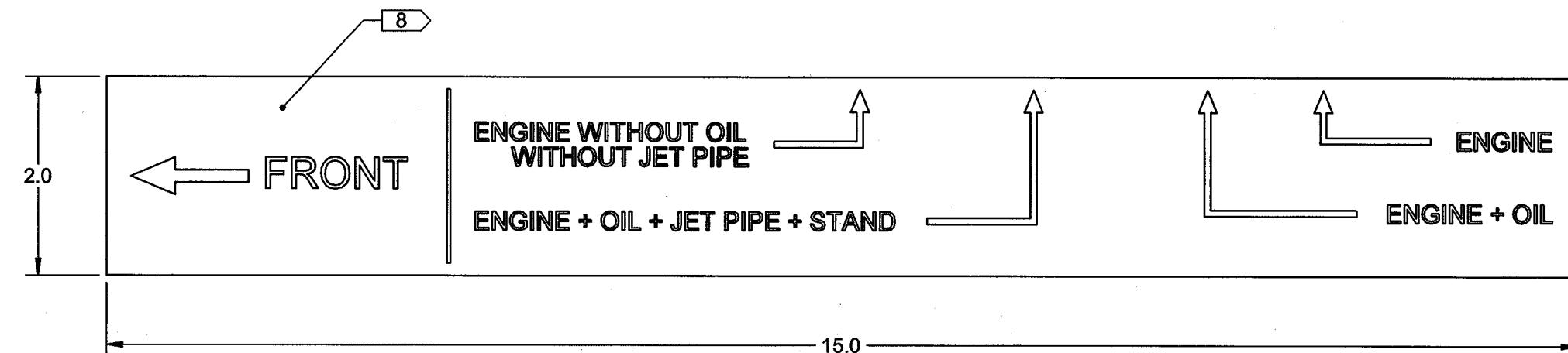
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HAWKESBURY, ONTARIO, CANADA

TOOL PART #  
**RBE332A91-5490-00**  
REV. A  
SHEET 10 OF 12  
TITLE  
**MAKILA 2A SLING TOOL**  
SCALE  
NTS

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**RBE332A91-5490-00-10 STICKER**

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**NOTES:**

1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) SILVER BACKGROUND WITH BLACK LETTERS AND ARROWS

9) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBE332A91-5490-00-10 REV. A3.DXF

|                       |            |
|-----------------------|------------|
| DESIGN<br>DRAWN       | KPT<br>KPT |
| CHECKED<br>MFG. APPR. | PM<br>DP   |
| APPROVED              | NO         |
| DATE                  | 1/10/2020  |

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

 TOOL PART #  
**RBE332A91-5490-00**

REV. A

SHEET 11 OF 12

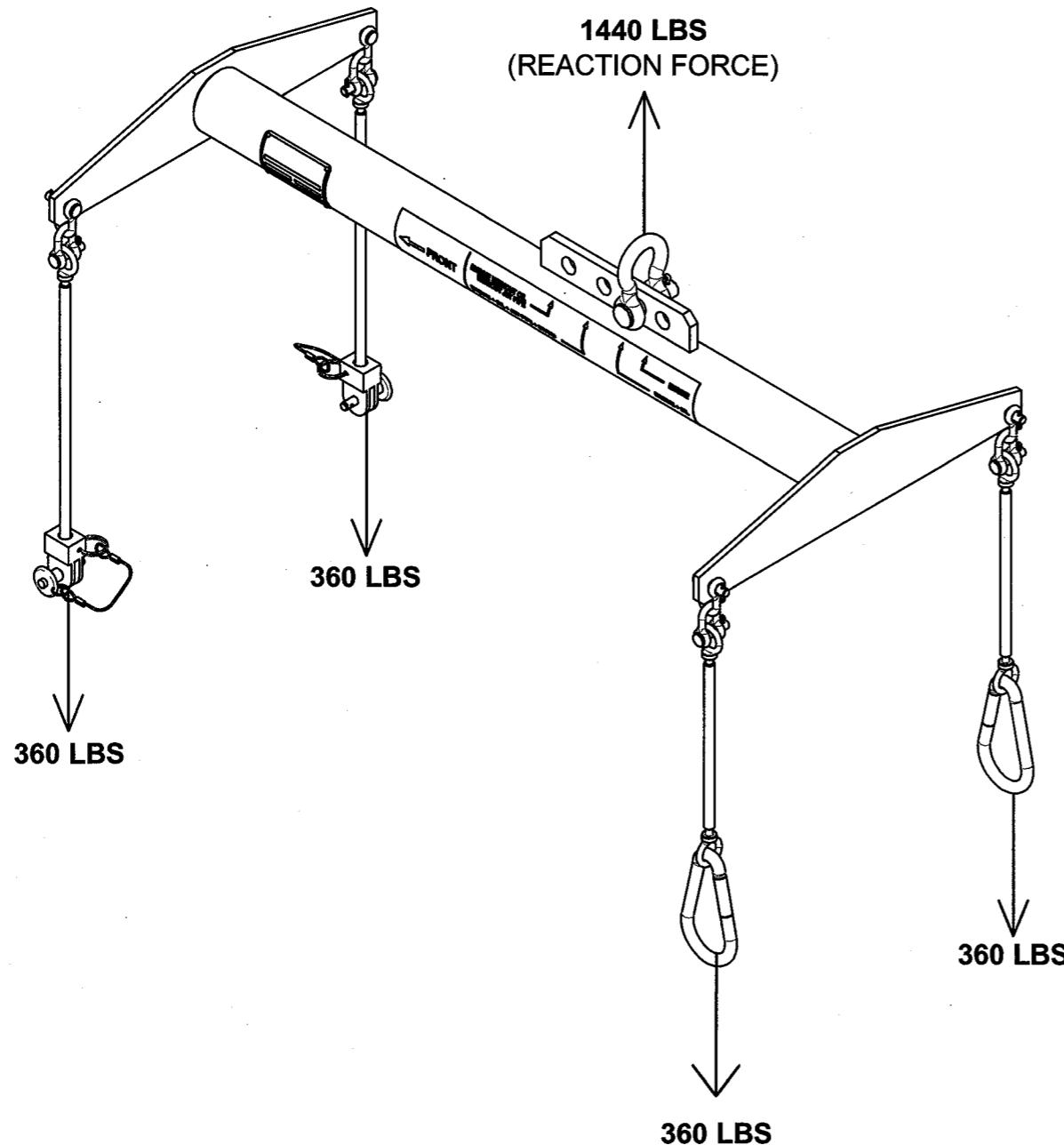
 TITLE  
**MAKILA 2A SLING TOOL**

 SCALE  

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INSPECTION AND TESTING PROCEDURE FOR THE RBE332A91-5490-00  
MAKILA 2A SLING TOOL. THIS ASSEMBLY SHOULD BE INSPECTED  
BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR  
SUSPECTED OF DAMAGE BEFORE USE.

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE INTO. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 654 KG / 1440 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTIONS, AND/OR DISTORTIONS
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR CRACKS, DEFLECTIONS, AND/OR DISTORTIONS
4. REPEAT STEPS 1 TO 3 FOR "ENGINE WITHOUT OIL WITHOUT JET PIPE", "ENGINE + OIL + JET PIPE + STAND", AND "ENGINE" HOLE POSITIONS

INSPECTOR: \_\_\_\_\_

TESTER: \_\_\_\_\_

S/N: \_\_\_\_\_

DATE: \_\_\_\_\_

|            |           |
|------------|-----------|
| DESIGN     | KPT       |
| DRAWN      | KPT       |
| CHECKED    | PM        |
| MFG. APPR. | DP        |
| APPROVED   | MD        |
| DATE       | 1/10/2020 |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
TOOL PART # RBE332A91-5490-00  
TITLE MAKILA 2A SLING TOOL  
REV. A  
SHEET 12 OF 12  
SCALE NTS

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